

Work Order ID 58641

Wednesday, May 12, 2010 1:42:18 PM



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Item ID:	D3684-047	Accept		Setup	Start	
Revision ID:						
Item Name:	FWD LEG ASS'Y				Stop	
Start Date:	5/13/2010	Start Qty: 8.00				
Required Date:	5/21/2010	Req'd Qty: 8.00				
Reference:						

Approvals:	Process Plan:	<u>MMF</u>	Date:	<u>10-5-12</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3684	Rev D								

100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

Sp 10/06/22

FA

110	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab									

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684

2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684

**Ensure holes for AN3C Bolts are free of sealant.
Torque Fastners as per Dwg D3684

Sp 10/06/22 (7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3684-047

Accept



Setup Start



Revision ID:

Stop



Item Name: FWD LEG ASS'Y

Start Date: 5/13/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 5/21/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/06/22

(x7)

130



Packaging

Packaging

Identify as per dwg & Stock Location: 1390

0.00

Memo

0.00

6/10/06/22 (7)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/23

U 10/06/22

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Picklist Print

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Work Order ID: 58641

Parent Item: D3684-047

Parent Item Name: FWD LEG ASS'Y

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM
IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Start Date: 5/13/2010

Required Date: 5/21/2010

Start Qty: 8.00

Required Qty: 8.00

AN3C12A

Purchased No 110 Each 104.0000 2



Bolts

Location

Loc Qty

Loc Code

ST351

104

112314

104

D3688-1

Manufactured No

110 Each

7.0000

1



STUD

Location

Loc Qty

Loc Code

ST080

7

50932

7

D3689-1

Manufactured No

110 Each

16.0000

1



SLEEVE

Location

Loc Qty

Loc Code

ST082

16

55638

11

56335

5

D3691-1

Manufactured No

110 Each

1.0000

1



STUD

Location

Loc Qty

Loc Code

ST082

1

54859

1

D 58631

14 SB 10/06/22

7 SB 10/06/22

7 SB 10/06/22

1 SB 10/06/22

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Start Date: 5/13/2010

Required Date: 5/21/2010

Start Qty: 8.00

Required Qty: 8.00

D3692-1 Manufactured No 110 Each 521.0000 4



SPACER

Location	Loc Qty	Loc Code
ST082	521	
50736	113	
51467	408	

28 SA 10/06/22

D3693-1 Manufactured No 110 Each 63.0000 1



Rod End Bearing

Location	Loc Qty	Loc Code
ST082	63	
50734	63	

7 SA 10/06/22

MS21043-3 Purchased No 110 Each 3,635.000 2



Nut

Location	Loc Qty	Loc Code
FG	80	
103691	80	
ST301	3555	
112314	3555	

14 10/06/22

NAS509-12C Purchased No 110 Each 69.0000 1



Nuts

Location	Loc Qty	Loc Code
ST280	69	
112453	69	

7 10/06/22

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Shop Packet Print

Page 2

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IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Start Qty: 8.00

Required Qty: 8.00

NAS509L12C

Purchased

No

110

Each

74.0000

1



Nuts

Location

Loc Qty

Loc Code

ST280

74

112314

64

112828

10

7

SB 10/06/22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

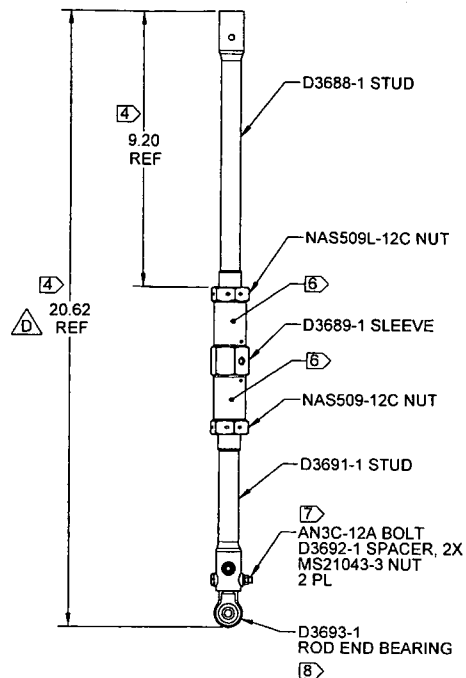
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ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D3684-047	FWD LEG ASSEMBLY
2	1	D3688-1	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



#58641





D3684-047 FWD LEG ASSEMBLY

RELEASED
2010-03-15

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-1 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.09 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3684	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
DATE	10.03.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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